

Abstract of the disclosure

A reduction to the traveling motion of bottles along a delivery conveyor in an intermittent motion decorating machine is provided by one of a pair of workpiece feed cams rotatably supported in a side-by-side relation to rotate about spaced horizontal axes lying in a common horizontal plane. The workpiece feed cams have feed cam tracks for receiving cam followers of each of plurality of vertical bottle carriers. One of the feed cam tracks reduces the speed of the bottle carriers from a relatively high entry speed corresponding to the through put speed in the decorating machine to the speed of the deliver conveyor for more densely populating the delivery conveyor with workpieces. Carrier transfer members at each of opposite ends of the workpiece feed cams transfer the bottle carriers from one to the other of the workpiece feed cams. A drive rotates the workpiece feed cams, carrier return cams and carrier transfer members. The decorating machine is provided with a registration station preceding spaced apart decorating stations. The registration station includes a drive to reduce the clamping pressure by chucks on a workpiece while establishing a predetermined orientation of each workpiece relative to the decorating stations.